

Date: Tuesday, 12/5/2006 8:14:36 AM
 User: Kim Johnston

Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X24")
Job Number	: 29771	Part Number	: D130700011
Estimate Number	: 10972	Drawing Number	: D3167 REV A1
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 12/5/2006 S.O. No. : <i>N/A</i>	Drawing Revision	: A1
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Due Date	: 12/23/2006
Previous Run	: 24974	Qty:	<i>5</i> Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 061205		
Comment	: Est Rev:J 04.02.17 Blank size changed KJ/JLM		

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy bluefile and create labels per PPP D130-700-011CHG001

KJ 07.01.04

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.9975 sf(s)/Unit Total: 34.9876 sf(s)
 blank: 20.00" x 24.00" x 1.00" thick (+0.030/-0.000)
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: *M103315*

J.F. 07/02/11

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA285 and Dwg D3167

3-Deburr

J.F. 07/02/11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/11

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Job Number: 29771

Part Number: D130700011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/02/02 X 5 (K.T.)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

mf. 07-03-08. (2)

7.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 2.0000 f(s)/Unit Total: 10.0000 f(s)

Pick: Packing Kit

*

Qty Part Number Description Batch

4 D2182B060 Rubber Cushion

B 30397 ✓

8.0	D2274	Radius Block
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

B 30518 ✓
B 29771 ✓

9.0	D2519	Clamp
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2519 Clamp

B 26216 ✓

10.0	D2529	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

B 30382 ✓

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Part Number: D130700011

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D31711 Angle



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D3171-1 Angle B18591 ✓

12.0 AN412A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-12A Bolt M102929 ✓

13.0 AN415A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt M103585 ✓

14.0 AN960JD416 Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M103338 ✓

15.0 MS21042L4 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M103349 ✓

mf. 07-03-08

Date: Tuesday, 12/5/2006 8:14:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 29771

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 7/3/8 (2)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-700-011

Location:

MVA

PC 7/3/8 (2)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

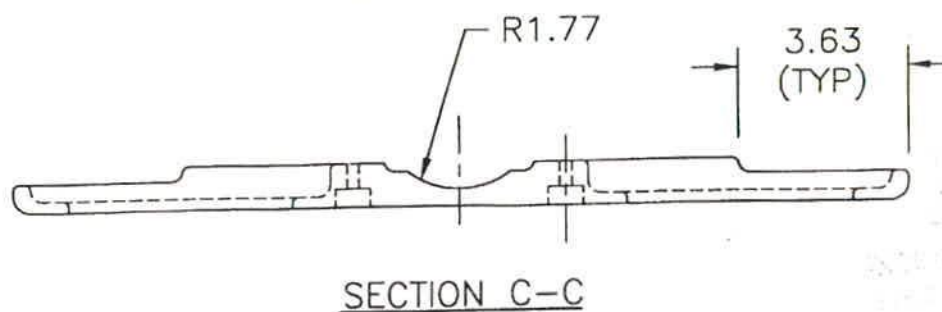
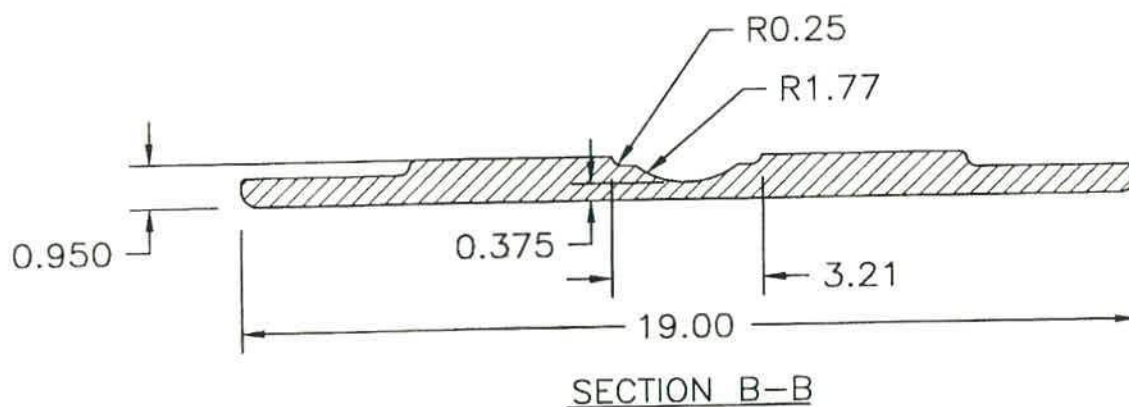
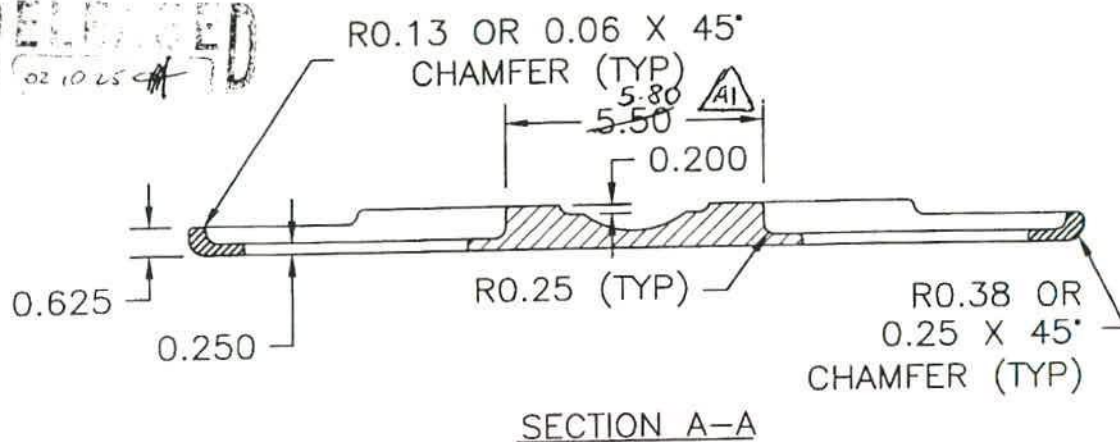


U 07.03.09



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

RELEASED
02.10.25



29771

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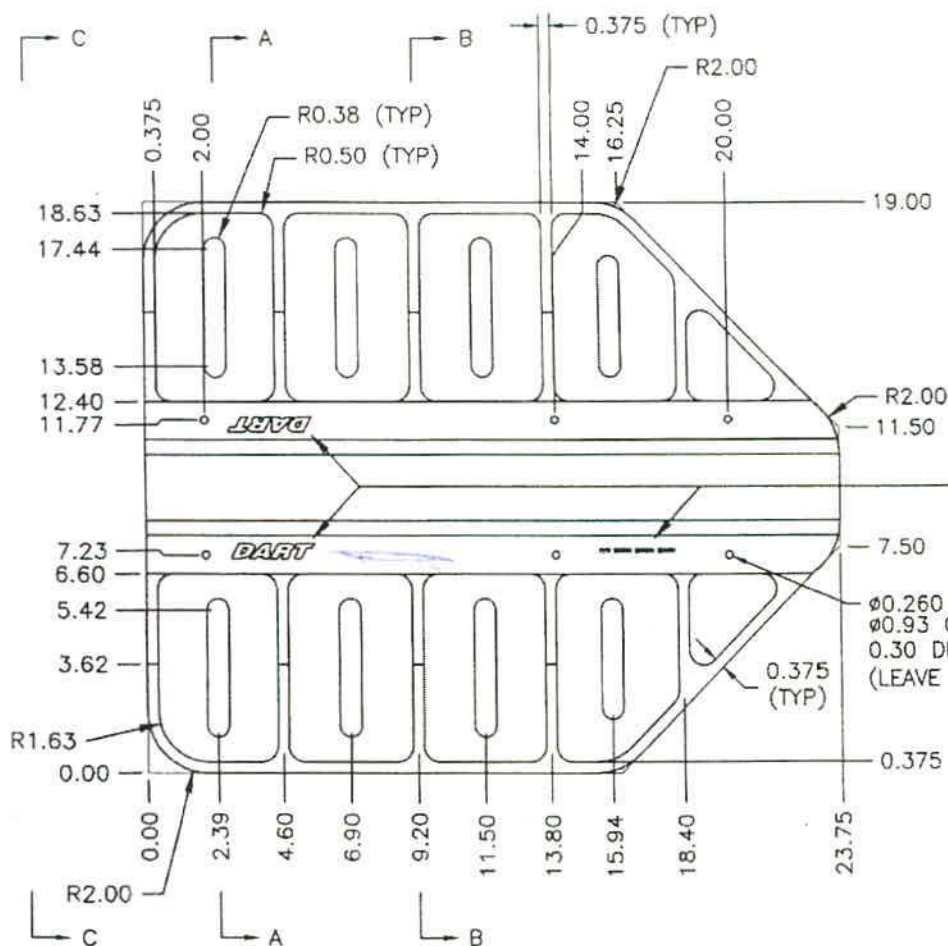
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DART



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		SHEET 1 OF 2	
02.10.08		BEARPAW		SCALE	
A		02.10.08		NEW ISSUE	
A1		02.12.17		5.80 WAS 5.50	

RELEASED
02.10.25



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

29771

DART AEROSPACE LTD		Work Order:	29771
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.5048	✓		
B	5.80	+/-0.030	5.787	✓		
C	0.25 x 45°	+/-0.030	2.8043	✓		
D	R0.25	+/-0.030	0.25	✓		
E	0.200	+/-0.030	0.205	✓		
F	0.250	+/-0.010	0.247	✓		
G	0.625	+/-0.030	0.615	✓		
H	0.375	+/-0.010	0.365	✓		
I	0.950	+0.030/-0.010	0.940	✓		
J	3.21	+/-0.030	3.200	✓		
K	19.00	+/-0.030	19.00	✓		
L	Ø0.260	+0.005/-0.000	0.259	✓		
M	Ø0.93	+/-0.030	0.931	✓		
N	0.30	+0.030/-0.000	0.330	✓		
O	0.375	+/-0.030	0.377	✓		
P	7.23	+/-0.030	7.219	✓		
Q	4.54	+/-0.010	4.539	✓		
R	2.00	+/-0.030	1.948	✓		
S	12.000	+/-0.010	12.000	✓		
T	6.000	+/-0.010	6.000	✓		
U	23.75	+/-0.030	23.750	✓		

Measured by: JF	Audited by: SA	Prototype Approval:	N/A
Date: 07/02/11	Date: 07-02-11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	✱

Date: Thursday, 20/12/2007 11:20:50 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D350-578/D130-700
Job Number	: 36464		
Estimate Number	: 10804		
P.O. Number	: <i>N/A</i>	Part Number	: Z_CUSTOM
This Issue	: 20/12/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: ECN 1095
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 00015	Drawing Revision	: <i>N/A</i>
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 27/12/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK:

D350-578-011

32785 (11x)

35312 (6x)

D350-578-021

30840

(6x)

D130-700-011

29771

(3x)

ADD NEW PAPERWORK TO KITS IN STOCK
 EASA STC: EASA.IM.R.S.01389, PER ECN 1095

RETURN TO STK

8/1/3 sd (26)

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

2008/01/03 (22)

Job Completion



2008/1/3
U

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 07.12.20	Job No.:	ADR Yes/No: N	ADR Date: N/A	ECN #: 1095
Product No.: D350-578/D130-700		Created By: [Signature]	Approved By: [Signature]	
Product Name: Bearpaws		Checked By: [Signature]	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	Y	LL	
Production Engineering Coord			
Director Quality Assurance			
Customer Order Processing	Y	BG/SB	

Distribution	Reqd	Resp	Received
Customer Technical Support			
Marketing	Y	SW	

Reason for Change:

Documents Affected:

RECEIVED EASA STC: EASA.IM.R.S.01389 dated 07.10.22

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	Y	KJ		07.12.20 [Signature]
2	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		07.12.20 [Signature]
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
4	Update Grey Project Binder	Y	KJ		07.12.20 [Signature]
5	Move Electronic Files	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Create/Update Change Record Form	N			
9	Create/Update PPP's	N			
10	Update Controlled PDF Files	N			
11	Notify TC/FAA of Change	N			
12	Update QSI 021 and/or STC Approval List	Y	KJ		07.12.20 [Signature]
13	Update Product Development Summary	Y	KJ		07.12.20 [Signature]
14	Update Accpac Database	N			
15	Update Access (ARC) Database	Y	KJ		07.12.20 [Signature]
16	Update/Verify ARC	Y	KJ		07.12.20 [Signature]
17	Update Paperwork Kits in Production	Y	KJ	D350-578-011 (6-B36035, 10-B36044)	07.12.20 [Signature]
18	Update Qpulse/Laminated Dwgs	N			
19	Update Product Compatability Matrix	N			
20	Create Eurocopter Form (FEE)	N			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	N			
23	Update FAI Sheets	N			
24	Create/Update CNC Programs	N			
25	Create/Update Tooling	N			
26	Red Tag Stock (Specify)	N			
27	Rework/Scrap Current Production and/or Stock	N			
28	Update Paperwork Kits in Stock	Y	LL	SEE BELOW	07.12.20 [Signature]
29	Create/Update MPP	N			
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	N			
32	Notify Eurocopter France	N			
33					

Description / Action:

D350-578-011 (18-in stock), D350-578-021 (6 in stock), D130-700-011 (3 in stock)